

Date: Wednesday, 1/11/2006 4:23:35 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206L BASKET BASE
Job Number	: 25445A	Part Number	: D2252041
Estimate Number	: 11273	Drawing Number	: UNDER REVIEW D2252 Rev. E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 1/11/2006 S.O. No. : N/A	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 2/20/2006
Previous Run	: 25389A	Qty:	1
Written By	: See COMMENT Below	Um:	Each
Checked & Approved By	: SEE ABOVE USER & DATE		
Comment	: Est Rev:l Revised as per Rev E 05-12-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D31661	Basket Hoop	
		Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)	
		Pick:	
		Qty Part# Description Batch	
		5 D3166-1 Hoop B26259	PD 06-04-16
2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 25.0000 f(s)/Unit Total : 25.0000 f(s) M100282 (251.34") 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M100023 (10.25") M100560 (127.78") PD 06-04-16	
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing.	
		Cut 5 D2235-1 From D3166-1	
		2- Cut Ribs as per Dwg D2252	
		3-Drill hole in D2252-1as per Dwg D2252	
		4-Deburr & Remove all Markings from Material	PD 06-04-16

4.0	D22531	Lug	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
		2 D2253-1 Gusset B12413	PD 06-04-16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:23:35 PM
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Drawing Name: 206L BASKET BASE

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Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D23273 Spacer Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2327-3	Bushing	B252823

PD

06-04-16

6.0 D2581 Mounting Bracket



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	D2581	Mounting Chanel	B252824

PD

06-04-16

7.0 D2254 Gusset for D206bskt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2254	Lug	B25121

PD

06-04-16

8.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-3	HINGE	B25239

PD

06-04-16

9.0 D22531 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2353-1	LUG	B25239

10.0 M304EX0.75-16F Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty	Part Number	Description	Batch
32 sf	M304EX0.75-16F	Expanded Metal	M100722

PD

06-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 01/05/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET BASE

Job Number: 25445A

Part Number: D2252041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D2252 using Welding Table and corner JigDeburr as required

A/R SS ROD Batch: M100372

PD

06-04-27

12.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

M 06/04/27

13.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/04/28 ①

14.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JUN-05-02

15.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A

n

16.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DL 06/05/03

Job Completion



06.05.03

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

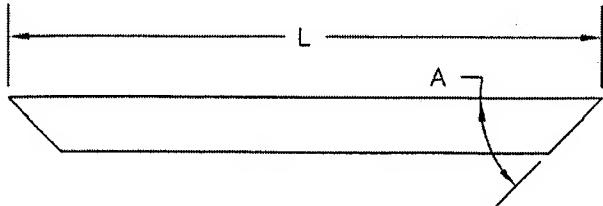
DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKSLEY, ONTARIO, CANADA
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2252
		REV. E SHEET 1 OF 5
DATE 05.11.10		TITLE SCALE BASKET ASSEMBLY (206L) NTS
C	95.12.11	RE-DRAWN
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19

RELEASED
05.11.26 *#*

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
X		D2252-043	LID ASSEMBLY		
2		D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
	2	D2252-19	FRAME	95.27	45
	2	D2252-21	FRAME	30.82	90
	1	D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

**CUT SIZE DETAIL**

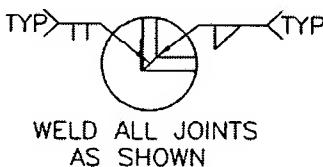
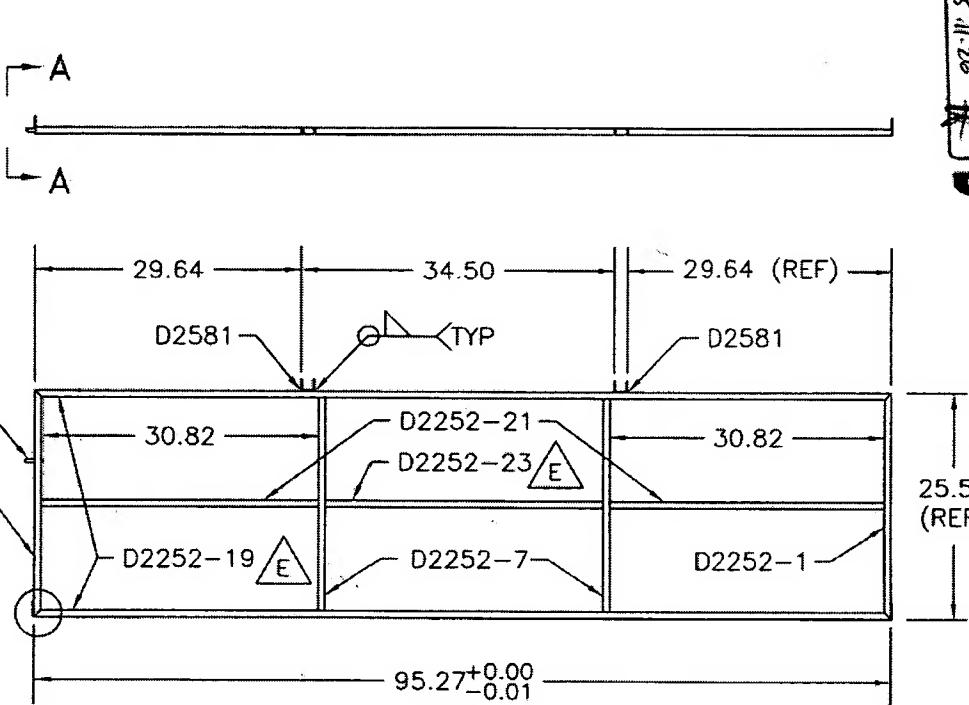
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05-11-26

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CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D2252	REV. E	SHEET 2 OF 5
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SCALE NTS		

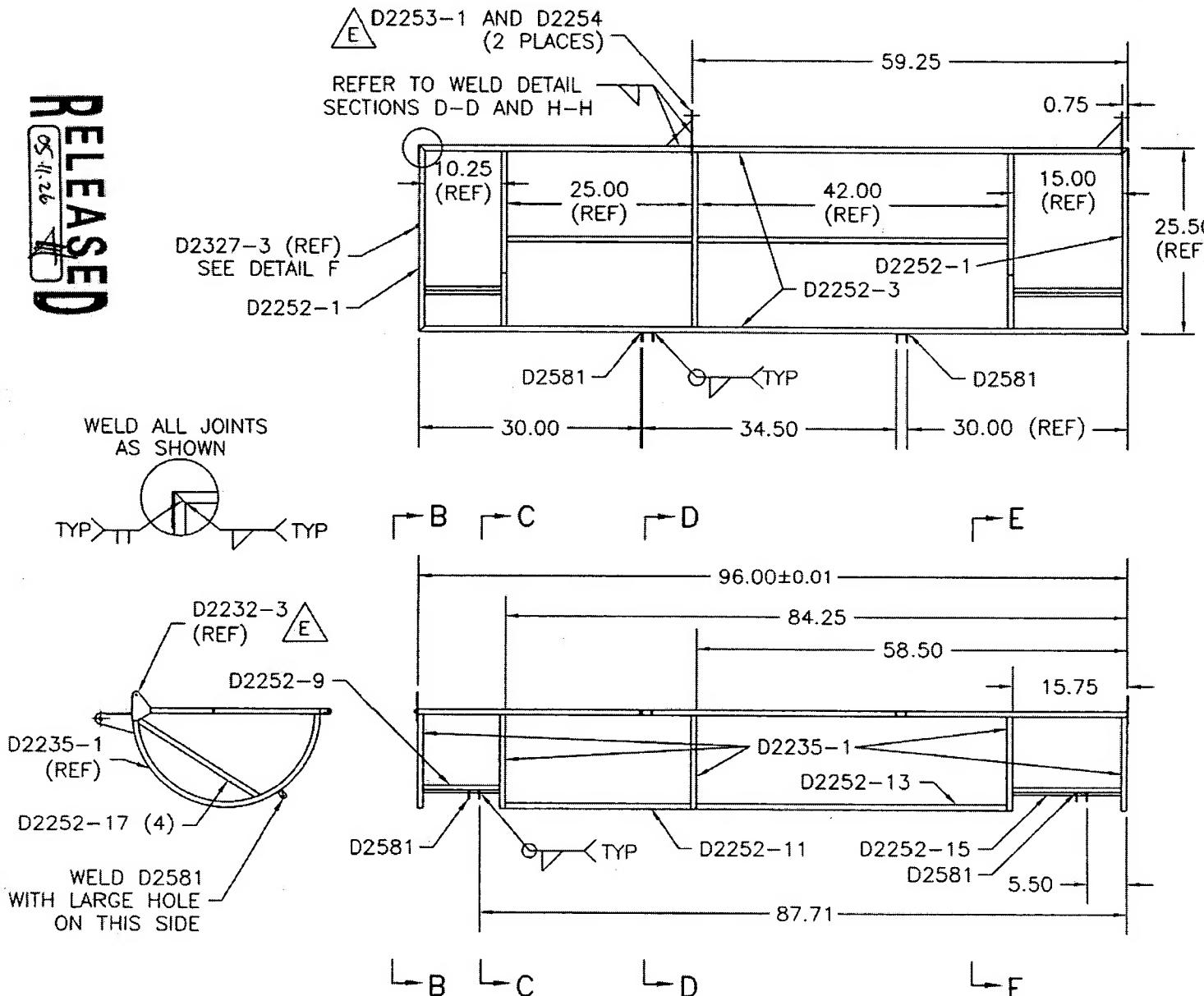


D2252-043 LID FRAME

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SHEET 3 OF 5	TITLE BASKET ASSEMBLY (206L)	SCALE N/A		

RELEASED
05.11.26



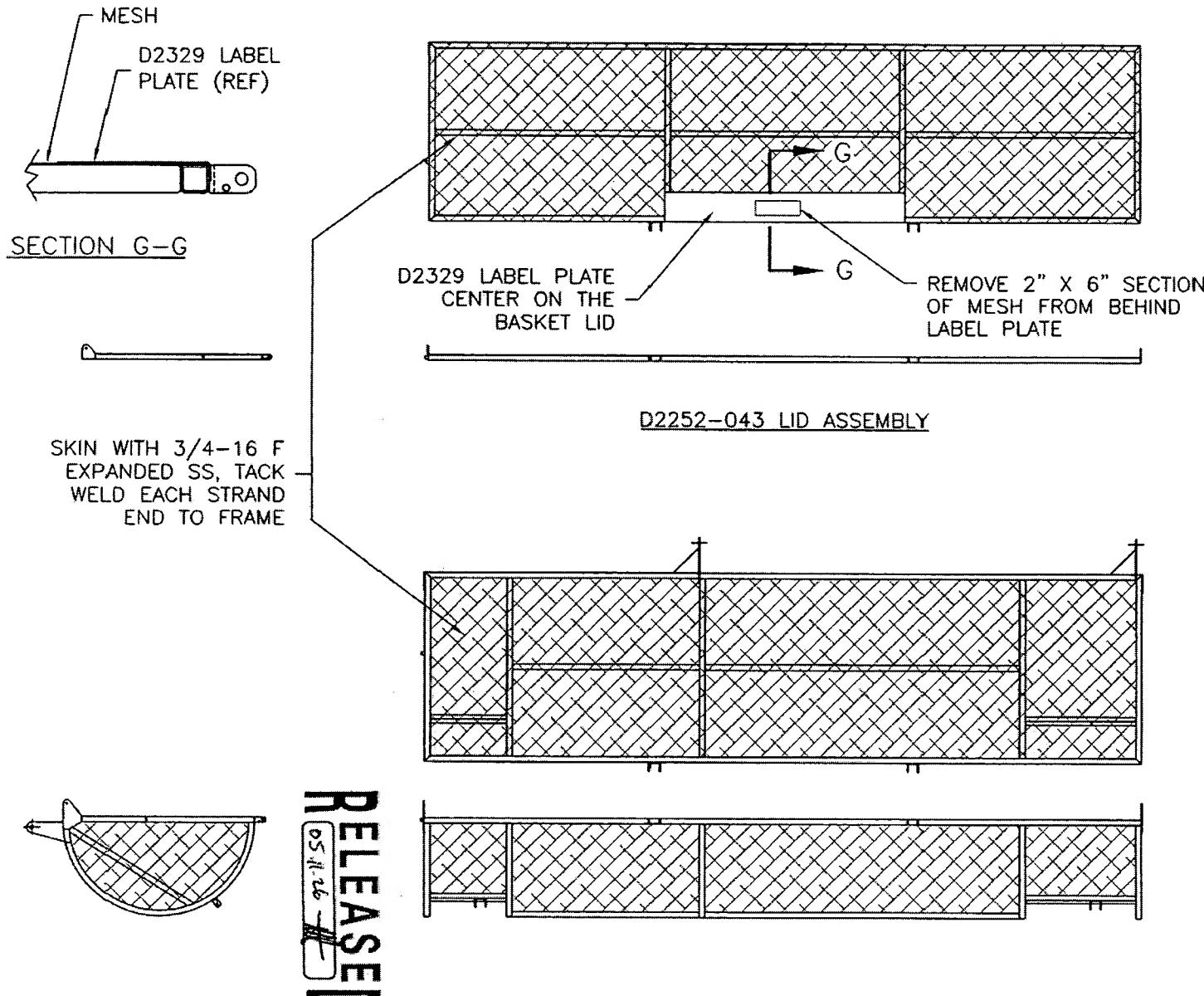
D2252-041 BASKET FRAME

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CHECKED <i>W</i>	APPROVED <i>W</i>	DRAWING NO. D2252
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	REV. E SHEET 4 OF 5 SCALE NMS



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2252	HAWKESBURY, ONTARIO, CANADA	REV. E
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SHEET 5 OF 5	SCALE N/A	

